

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010553**Date Inspected:** 29-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Assembly Area

Segment 5CE to 6AE

This Quality Assurance (QA) Inspector along with Mr. Manikandhan (QA Ct Inspector) measured and recorded the Mis-alignment and Offsets for T-Rib for Segment 5CE to 6AE between Panel Point (PP) 36 and PP 37 at following areas.

Bottom Panel

Side Panel Bike Path Side and

Side Panel Cross Beam Side.

Generated the report and submitted to Lead and Engineer for review.

Segment 5CW to 6CW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector along with Mr. Manikandhan (QA Ct Inspector) measured and recorded the Root Gaps and Offsets for Segment 5CW to 6AW between Panel Point (PP) 36 and PP 37 at following areas.

Bottom Panel

Side Panel Cross Beam Side

Side Panel Counter Weight Side

Edge Panel Cross Beam Side

Edge Panel Counter Weight Side

Deck Panel

Generated the report and submitted to Lead and Engineer for review.

Segment 5CW to 6CW

This Quality Assurance (QA) Inspector along with Mr. Manikandhan (QA Ct Inspector) measured and recorded the Offsets for Segment U-Rib to U-Rib for Segment 5CW to 6AW between Panel Point (PP) 36 and PP 37 at all the 39 Locations Left side and Right side of U-Rib.

Generated the report and submitted to Lead and Engineer for review.

Segment 1BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Segment 1BW for Weld connecting Edge Panel to Deck Panel. The weld joint number was identified as CA 107 -004. The welder is identified as 054013. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-2G(2F)-FCM-Repair-1. Noticed the parameter recorded by QC complies the WPS.

Segment 5CW to 6AW

This QA Inspector observed ZPMC welding personnel performing flame cutting for the weld connecting Side Panel to Bottom Panel Counter Weight side as Mis-alignment found at Bottom Panel to Side Panel. The activities are performed against the Welding Repair Report BWR8847 Rev.0.

Segment 6AW to 6BW

This QA Inspector observed ZPMC personnel performing fit-up for the Segment to Segment for 6AW to 6BW between PP 40 and PP 41.

Segment 5CE to 6AE

This QA Inspector observed ZPMC personnel performing Heat Straightening for Longitudinal Stiffener to Longitudinal Stiffener for Segment 5CE to 6AE between PP 36 and PP 37. The Heat Straightening activity was performed against HSR 1(B)-7875 Rev. 0 Dated Nov 08, 2009.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Segment 6BW to 6CW

This QA Inspector observed ZPMC personnel performing fit-up for the Segment to Segment for 6BW to 6CW between PP 43 and PP 44.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
